	er ID 119575 2014 1:36:47 PM		*119575*									
Item ID: Revision ID: Item Name:	D3417-5 Washer		Accept	*N900	0040	100	<b>)</b> *	Setup Sta	171	S1* S2*		
Start Date: Required Date: Reference:	5/15/14 Start Qty: 20.00 5/15/14 Req'd Qty: 20.00	, , ,		Cust Item					1 4	. 1/		
Approvals:	Process Plan: QC:	,	Tooling: SPC (Y/N):		ate:		]	Run Sta Sto	^ \ <u>\</u>	R1* R2*		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
Draw Nbr	Revision Nbr				<u></u>							
D3417	Rev F											
100 <b>*1</b>	Hardinge CNC LATHE	SMALL	0.00			<del>-</del>	20	Ø	<b></b>	DAS 40 9-89		
Doosan Lathe	Memo 1-Turn as <sub>I</sub> Rev: _▲▲ Dwg D341 2-Deburr	per Folio FA761 _ & 7 Rev:	0.00					·		14/06/10		
<sup>110</sup> <b>*11∩*</b>	QC2- Inspect parts off	machine FAI/FAIB	0.00				20	Ø		DAS 40 9-89		
QC Quality Control	Memo		0.00							14/06/10		
120	QC8- Inspect parts - sec		0.00							DAS		
*120* oc	Memo		0.00				20	Ø		20 9-89 14-06-11		

0.00

Memo

Quality Control

DQA:		Date:											$r @ A C^2$
					<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UPDAT	ΓΕ				AEROSPACE
QA Closed:		Date:							Wo	ork Order up	date only	$\Box$	
	•				DISPOSITION			AG	SAINST DE	PARTMENT	PROCESS		
Work Order:						,				1		$\neg$	- · · □
					Rework	li		<b></b>	sstube		Water Jet	4	Engineering
Part No	•				Scrap			~ <u>}</u>	nall Fab	4	d. Eng. Coor. re/Packaging	$\dashv$	Quality Other
NCD No					Use-as-is		Inern	~ <del></del>	nishing nposite	Kec/Stor	Supplier	$\dashv$	
NCR No	•				Suspected Unapproved	J		Large Fab Com	ibosite[	]	Subblief		
Root	Ţ		[	Desc	ription of work order update		nitial	Action		Sign &			<del></del>
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	۱	QC Inspector
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Doc/Data			i										
Equip/Tooling													
Handling/Pre												ł	
Material													
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Process													
Supplier	_												
Training	4												
Transport	4	İ										ļ	
Unapproved				<u> </u>		<u> </u>			<del></del>				
") j						FA	ULT CA	TEGORY			*		
Landing				_	General	$\overline{}$	11:- /5	)		Outside Dim	onsions [	$\neg$ <sub>B</sub>	ressure/Forced
<u> </u>	Bending	-+ C		-	Bend BOM/Bouto	$\vdash$	Grain	Program	-	Over/Under	· · · · · · · · · · · · · · · · · · ·	_	et-up
-		ot Conce	ntric	-	BOM/Route Broken/Damage/Defect	$\vdash$	Hardwa	aro	-	Part Incorred	l l	_	emperature/Cure
\ <del> </del>	Cracks	nk/Binnla	MAINO		Burrs	-	-{	ion Incomplete/Unqualifi	ied	Part Lost/Mi		_	Veld
-	Crimp/Ki Cuffs	lik/kihhie	y wave	-	Contamination	$\vdash$	4 ·	tions Incomplete/Unclear	<del></del>	Part Moved	331116		Vrong Stock Pulled
20	Crushing			<u> </u>	Countersink	-	-1	gned/off center	` <del> </del>	Positioned V	Vrong		
122	Heat Tre			<u>                                   </u>	Cut Too Short		Mislabe	=		Power Loss/		$\Box_{C}$	Other
<b> </b>	⊣	n Strip in	Tube		Drawing		Misrea			J : ==3=4	~ (		
<b> </b>	Marks/C				Drill Holes		Off-set						
<b> </b>	_	Sequence			Finish		4	Calibration					
	<b>⊣</b>	vist in Tul			Fit/Function		4	Sequence					

Page 2

Insp.

26

Work Order ID 119575 \*119575\* Friday, May 16, 2014 1:36:47 PM Item ID: D3417-5 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Washer **Start Date:** \*20\* 5/15/14 **Start Oty: 20.00 Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 20.00 \*20\* **Customer:** Reference: Start Run Date:\_\_\_\_\_ **Approvals: Process Plan:** Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Work Center ID Description **Run Hours** Code Qty Oty Number Stamp 130 Identify as per dwg & Stock Location: 0.00 \*130\* Packaging 0.00 Memo **Packaging** 140 QC21- Final Inspection - Work Order Release 0.00

\*140\*

QC Quality Control

Memo

0.00

DQA:			Date:			<b>.</b>							TRACT
						WORK ORDER NON	I-C	ONFO	RMANCE / UI				AEROSPACE
QA Closed:			Date:							<u> </u>	Nork Order up	odate only	
						DISPOSITION				AGAINST E	EPARTMENT	/PROCESS	
Work Orde	er: _					<b>D</b>	ר		ماريم المنادة	Crosstub o [	7	Water Jet	Engineering
Dowt N	ماء					Rework Scrap	-	,	Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Quality
Part N	۱O					Use-as-is	1		noforming	Finishing	_	re/Packaging	Other
NCR N	N۵					Suspected Unapproved	-	1116111	Large Fab	Composite	- 1100,310	Supplier	1
iven i	10.			**-		Suspected Shapproved			20.80 102		<b>-</b>	1.11	
Root					Desc	ription of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data					}								
Equip/Tooling													
Handling/Pre	Ш												
Material	Ш												
Operator											·		
Offset/Setup				 			ł						
Process	Ш												
Supplier													
Training													
Transport			1										
Unapproved		<u> </u>	<u> </u>	<u> </u>	l	<u> </u>		III T CA	TEGORY				
1		<u> </u>		· ·		General	FA	OLI CA	IEGORT				
Landi	ng C					Bend			Program	. [	Outside Dim	nensions F	Pressure/Forced
	-	Bending	ot Concer	ntric	-	BOM/Route	$\vdash$	Grain	rogram	· •	Over/Under	<del> </del>	Set-up
	-	Cracks	ot concei	ILLIC	┢	Broken/Damage/Defect	$\vdash$	Hardwa	are		Part Incorre	<del> </del>	Temperature/Cure
	$\vdash$	Crimp/Ki	nk/Rinnle	/Wave	$\vdash$	Burrs	-	_	ion Incomplete/Ur	ngualified	Part Lost/M	<del>-</del>	Weld
	H	Cuffs	ing mppic	, wave		Contamination	$\vdash$	-	tions Incomplete/L		Part Moved		Wrong Stock Pulled
	-	Crushing			-	Countersink	<b> </b>	Misali	gned/off center	100	Positioned \	<u> </u>	
	-	Heat Trea				Cut Too Short		Mislab		No.	Power Loss,	_	Other
		Inspectio		Tube		Drawing		Misrea		i, i, -			
		Marks/Cl				Drill Holes		Off-set					
1		4	Sequence			Finish		Out of	Calibration				
1		Wave/Tv	vist in Tuk	oe .		Fit/Function	$oldsymbol{oldsymbol{oldsymbol{oldsymbol{\Box}}}$	Out of	Sequence				

Picklist Print

Friday, May 16, 2014 1:36:50 PM

Work Order ID: 119575

<sup>75</sup> \*119575\*

Parent Item:

D3417-5

\*D3417-5\*

Parent Item Name:

Washer

**Start Date:** 5/15/14

Required Date: 5/15/14

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP Rev:ANew issue08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
MDELRINR1.2500		Purchased	No			110	f	24.0000	0.0296	0.623158				DAS
*MDFI RIN	· · · · · · · · · · · · · · · · · · ·	ንበ*							**			14/6	6/10	40 9- <b>8</b> 9

DELRIN ROUND BAR 1,25" color: black

DQA:			Date:											
						WORK ORDER NON	I-CC	ONFO	RMANCE / UPDATE			,		AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only		
Morle Ordo						DISPOSITION			AGAINS	T DEI	PARTMENT	/PROCESS		
Work Orde	er: _	<u> </u>				Rework	٦		Skid-tube Crosstube			Water Jet	П	Engineering
Part N	ام					Scrap	1		Machining Small Fal	-	Pro	d. Eng. Coor.	H	Quality
raitiv	··· –	-			<del></del>	Use-as-is	┨ ┃		noforming Finishin	-		re/Packaging	Н	Other
NCR N	lo.					Suspected Unapproved	1	,,,,	Large Fab Composite	~⊢	•	Supplier	П	
	_	-					_						_	
Root	Ţ				Desc	ription of work order update	1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
Design	_													
Doc/Data	_												Ì	
Equip/Tooling	_													
Handling/Pre														
Material			!											
Operator	_													
Offset/Setup	_													
Process	_													
Supplier	_		1											
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Unapproved			<u> </u>		_				TECORY		<del></del>	<u> </u>		
							FA	ULI CA	TEGORY		<del></del>	····		
Landir	$\overline{}$					General	_	احدانه اد	Program		Outside Dim	oncions		Pressure/Forced
	_	Bending			.	Bend BOM/Bouts	$\vdash$	Grain	Togram	-	Over/Under		$\vdash$	Set-up
	-	Centre No	ot Concer	itric	$\vdash$	BOM/Route Broken/Damage/Defect	$\vdash$	Hardwa	ore	$\vdash$	Part Incorre		-	Temperature/Cure
}	-	Cracks	ale/Diamlo	AMorro		Burrs	$\vdash$	4	tion Incomplete/Unqualified	$\vdash$	Part Lost/Mi		-	Weld
	$\overline{}$	Crimp/Kir Cuffs	ik/kibbie	y wave	. —	Contamination	-	4 '	tions Incomplete/Unclear	$\vdash$	Part Moved	.551116	-	Wrong Stock Pulled
	-	Crushing			-	Countersink		4	gned/off center	_	Positioned V	Vrong	ш	
}	-	Crusning Heat Trea	at .			Cut Too Short	-	Mislabe	-	_	Power Loss/	_		Other
	-	Inspection		Tube		Drawing	-	Misrea			1. 55. 2550/			
}	-	Marks/Ch	-	· ubc		Drill Holes		Off-set						
}	-		equence		<b>-</b>	Finish	-	-	Calibration					
		Turning 5	Euucine			11 11 11 13 11		TOUL OF	Calibration					

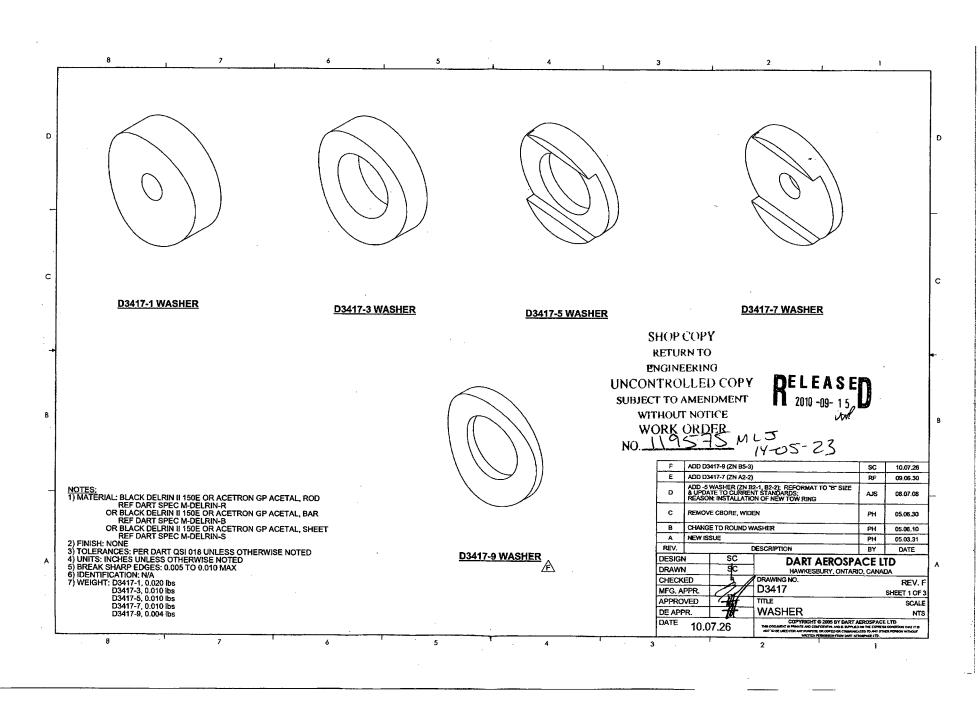
DART AEROSPACE LTD	Work Order:	119575
Description: Washer	Part Number:	D3417-5
Inspection Dwg: D3417 Rev: F		Page 1 of 1

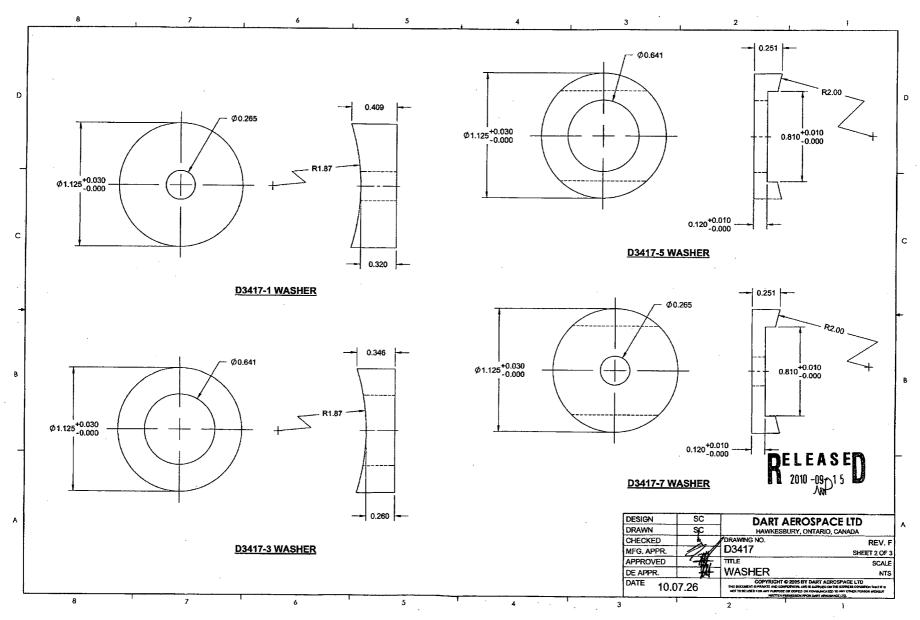
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.125	+0.030/-0.000	1,140			VEW	P4D-12
Ø0.641	+0.008/-0.001	,643	1		n	
0.120	+0.010/-0.000	. 123			84	•
0.810	+0.010/-0.000	- 810	/		1.	* *
0.251	+/-0.010	.25			<b></b>	<i></i>
R2.00	+/-0.030	2,00	/		Pad 6	
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Rev	Date	Change	Revised by	Approved
Α	09.05.04	New Issue	KJ/DD	
В	10.11.12	Dwg Rev updated	KJ .A	
С	12.07.31	Dwg Rev updated	KJ 👭	[11]
		<u> </u>		





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0.181 Ø0.641 Ø1.125<sup>+0.030</sup><sub>-0.000</sub> 0.078 --**D3417-9 WASHER** DESIGN DRAWN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. F SHEET 3 OF 3 MFG. APPR. APPROVED SCALE WASHER COPYRIGHT 6 2000 DE APPR. 4 DATE 10.07.26 NTS